

# Work Order ID 122488

Tuesday, July 22, 2014 8:37:59 AM

**\*122488\***

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Item ID: D4287-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Uhmw U-Channel  
 Start Date: 7/21/14 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 7/21/14 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: MCS Date: 14-07-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4287	A								
100		0.00							
<b>*100*</b>									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>25136</u>								
	Material: UHMW (white)								
	Supplier P#: McMaster-Carr 8672K31								
	Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

CL 14/07/24 40

P 14/7/28 (40)

**DAS**  
**16**  
**9-89** 14/7/31



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO25136**

Purchase Order Date 7/24/2014

PO Print Date 7/24/2014

Page Number 1 of 4

**Order From :**

MCMaster-CARR SUPPLY CO,  
P.O. BOX 7690  
CHICAGO, IL 60680-7690  
US

VU-MCM001

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**

**Contact Name**

**Vendor Phone** 330 995 5500

**Ship To Contact**

**Ship To Phone**

**Ship Via:** Purolator ground ppd

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #**

10127-2607

**Terms**

Net 10

**Currency**

USD

**FOB**

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							
1	1722A42	Holder	7/28/2014		50.00	\$0.76	\$38.00
			Yes		Each		
			7/28/2014				
	AS PER DWG D4004 REV. B B122491						
						Line Total:	\$38.00
2	8672K31	UHMW U-Channel	7/28/2014		40.00	\$3.26	\$130.40
			Yes		f		
			7/28/2014				
	AS PER DWG D4287 REV. A B122488						
						Line Total:	\$130.40
3	9928K53	UHMW U-Channel	7/28/2014		24.00	\$2.28	\$54.72
			Yes		f		
			7/28/2014				
	AS PER DWG D4287 REV. A B122562						

**Note:**

7/24/2014



200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Purchase Order  
PO25136

Order Placed By  
Chantal Lavoie

McMaster-Carr Number  
6762542-02

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07/24/2014

Line	Description	Ordered	Shipped	LNS		
3	9928K53 Impact-Resistant UHMW Polyethylene U-Channel, 1" Base X 3/4" Legs, 1/4" Thick Your Part Number: B122562	24 Feet	24	5 - 23 - 13	69 - 51 K53	24 FT 3
2	8672K31 UHMW Polyethylene Trim, Screw Mount, U-Shape, 1" Inside Width Your Part Number: B122488 <i>8.14.13</i>	40 Feet	40	5 - 23 - 15	64 - 45 K31	40 FT 2
4	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	4			

Shipped separately from our Chicago warehouse on 07/24

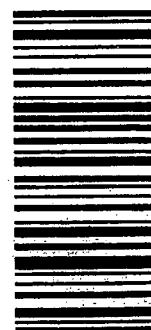
#### Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog. Your order is subject only to our terms and conditions, available at [www.mcmaster.com](http://www.mcmaster.com) or from our Sales Department.

Jason Wolfe  
Compliance Manager

Dart Aerospace Ltd

EXP



13 lbs  
2 lines

FW1BSP52  
07/24/2014  
11:58/13:17  
343  
Cycle 45

1141200554316



PI

Long  
Straights

# MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D4287-3  
 DATE: 2014/07/31

PO / BATCH NO.: B/22488  
Po # 25136

MATERIAL CERT REC'D: 7C3  
 QUANTITY RECEIVED: 40'  
 QUANTITY INSPECTED: 40'  
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.125"  
 THICKNESS RECEIVED: 0.126"  
 SHEET SIZE ORDERED: 0.75' x 1.25'  
 SHEET SIZE RECEIVED: 0.73' x 1.254"

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	N	
CORRECT FINISH	Y	N	
CORROSION	Y	N	
CORRECT GRAIN DIRECTION	Y	N	
CORRECT MATERIAL	Y	N	
CORRECT THICKNESS	Y	N	
PHOTO REQUIRED	Y	N	
CORRECT MATERIAL	Y	N	56 72K 31
CORRECT REF # TO LINK CERT	Y	N	Po # 25136
CORRECT MATERIAL IDENTIFICATION	Y	N	D4287-3
CORRECT M# ON THE MATERIAL	Y	N	B 122488
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS</u> DATE: <u>16 9-89 14/07/31</u>	SIGNED OFF BY: _____ DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

# **MATERIAL RECEIPT INSPECTION FORM**

## **INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK**

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
  - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

## **INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION**

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

### **AFTER MATERIAL PASSES INSPECTION**

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

## **INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL**

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
  - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
  - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
  - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
  - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER